

Work Order ID 80698

February-27-12 2:53:13 PM

80698

Page 1

Item ID: D4092-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Maintenance Step Assembly

Start Date: 27/02/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/02/12 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4092	B								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg Torque screws up to 15-25 in- lbs								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

EP 12/03/07 (2)

EP 12/03/07 (2)

(+2)

8/12/12/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80698***80698***

Page 2

February-27-12 2:53:13 PM

Item ID: D4092-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Maintenance Step Assembly
Start Date: 27/02/2012 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 12/03/2012 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging	PPD 80906								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 12/03/07
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

February-27-12 2:53:17 PM

Page 1

Work Order ID: 80698

80698

Parent Item: D4092-042

D4092-042

Parent Item Name: Maintenance Step Assembly

Start Date: 27/02/2012

Required Date: 12/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED:DD
REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 *D4092-1* Maintenance Step		Manufactured	No				Each	11.0000		4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				10					
				77852				10					
				ST241A				1					
				74303				1					
D4093-1 *D4093-1* Bracket		Manufactured	No				Each	12.0000		2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST124				12					
				78911				12					
D4093-3 *D4093-3* Bracket		Manufactured	No				Each	6.0000		2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST124				6					
				77850				6					
D4093-5 *D4093-5* Bracket		Manufactured	No				Each	24.0000		4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST124				24					
				80085				4					
				80226				20					

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Page 2

Work Order ID: 80698

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Parent Item: D4092-042

D4092-042

Parent Item Name: Maintenance Step Assembly

Start Date: 27/02/2012

Required Date: 12/03/2012

Start Qty: 2.00

Required Qty: 2.00

MS24694-S54

Purchased

No

Each

118.0000

MS24694-S54

Screw

**

4
2/23/07

Location

Loc Qty

Loc Code

ST289A

118

120142

18

120361

100

4

MS24694-S55

Purchased

No

Each

135.0000

MS24694-S55

Screw

**

16
2/23/07

Location

Loc Qty

Loc Code

ST289A

135

119307

33

120142

52

120833

50

16

MS24694-S56

Purchased

No

Each

75.0000

MS24694-S56

SCREW

**

4
2/23/07

Location

Loc Qty

Loc Code

ST289A

75

120142

50

120833

25

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 80698

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Parent Item: D4092-042

D4092-042

Parent Item Name: Maintenance Step Assembly

Start Date: 27/02/2012

Required Date: 12/03/2012

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0332J

Purchased

No

Each

2,271.000

24

NAS1149D0332.J

**

Washer

Location

Loc Qty

Loc Code

ST298

2271

105793

12

110985

4

117087

89

119042

276

119717

890

120644

1000

24
2/23/07

24

MS21042L3

Purchased

No

Each

4,087.000

24

MS21042L3

**

Nut

Location

Loc Qty

Loc Code

ST300

4087

117441

16

117885

32

118451

5

118927

3

119017

3834

119075

197

24
2/23/07

24

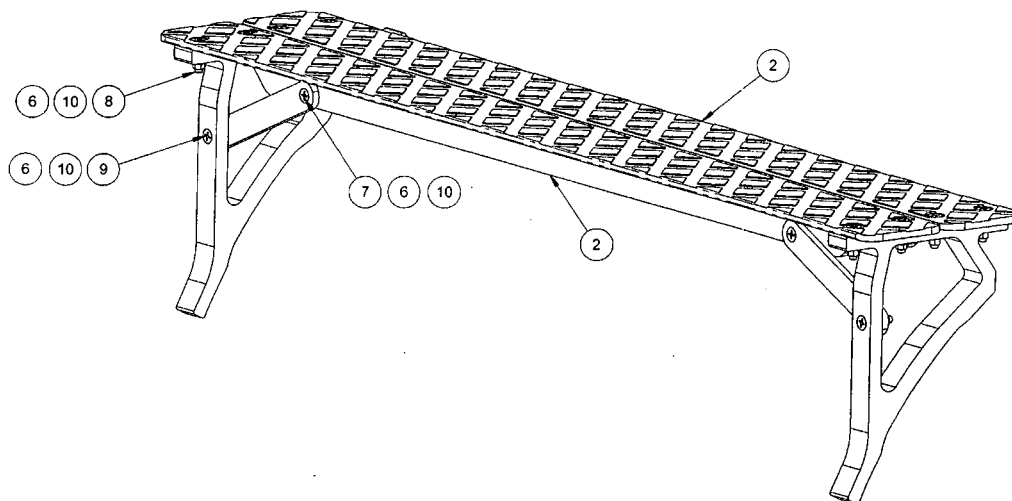
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



D4092-041 MAINTENANCE STEP ASSEMBLY

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

SEE
REF. NO. 1
PART NO. 1
UNCONTROLLED COPY
SUBJECT TO CHANGE
WITH NO. 1
WORK ORDER
NO. 80698

RELEASED
2011-09-22
MWP

B	REDRAWN; LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	MWP	DRAWING NO.	REV. B
MFG. APPR.	MWP	D4092	SHEET 1 OF 6
APPROVED	MWP	TITLE	SCALE
DE APPR.	MWP	MAINTENANCE STEP ASS'Y	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

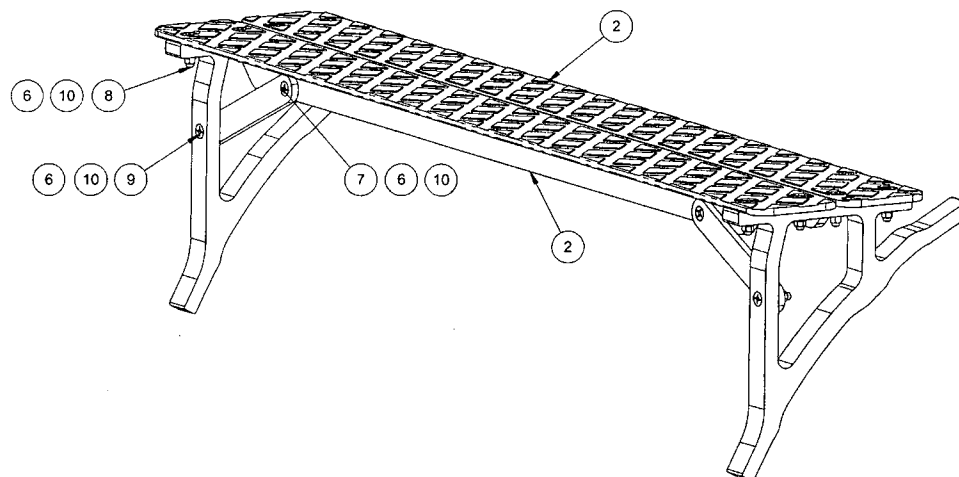
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER



D4092-042 MAINTENANCE STEP ASSEMBLY

B

RELEASED
2011-09-20
JW

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	NTS
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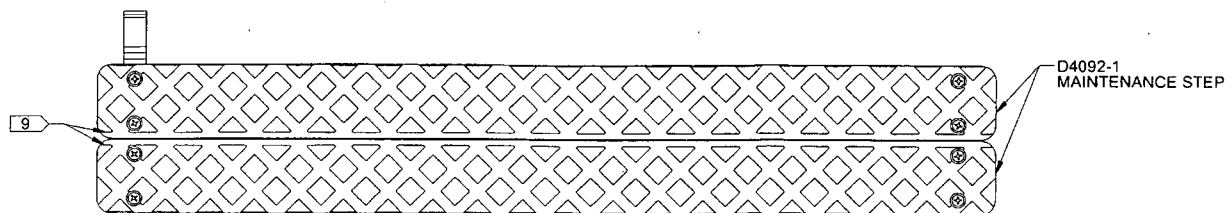
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

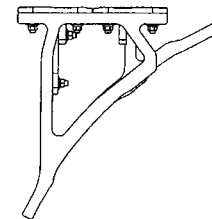
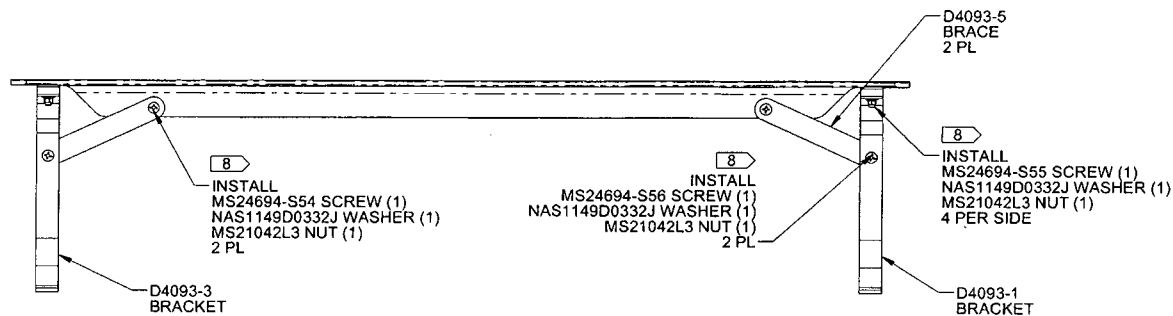
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



80698



D4092-041 MAINTENANCE STEP ASSEMBLY

RELEASED
2011-09-22

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 3 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

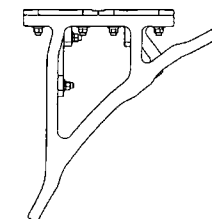
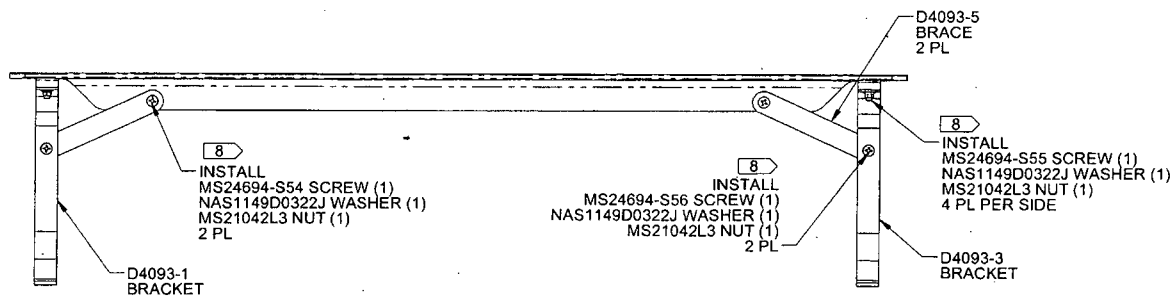
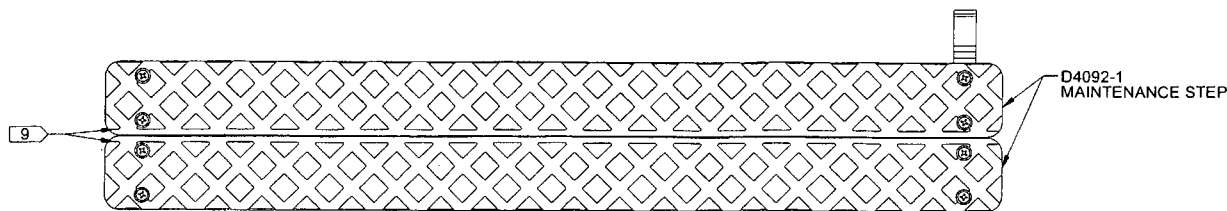
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80698



RELEASED
2011-09-22
MCO

D4092-042 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART-QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	21	D4092	SHEET 4 OF 6
APPROVED	140	TITLE	SCALE
DE APPR.	140	MAINTENANCE STEP ASS'Y	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

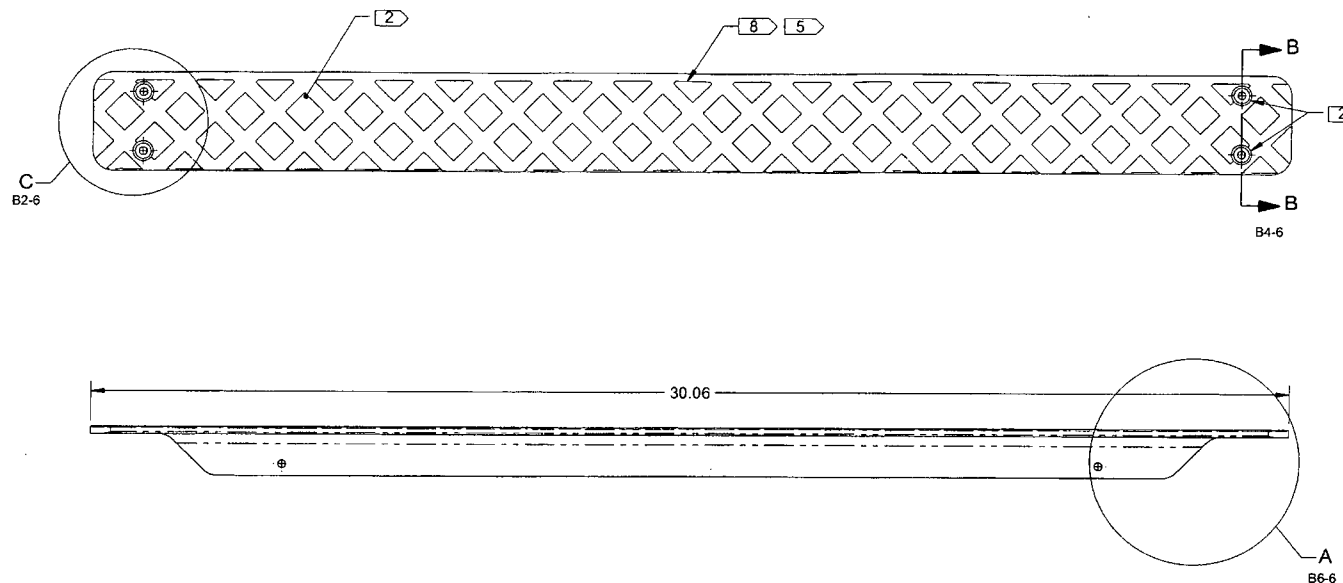
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

NOTES:

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

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R 2011-09-22
JW

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	SA	D4092	SHEET 5 OF 6
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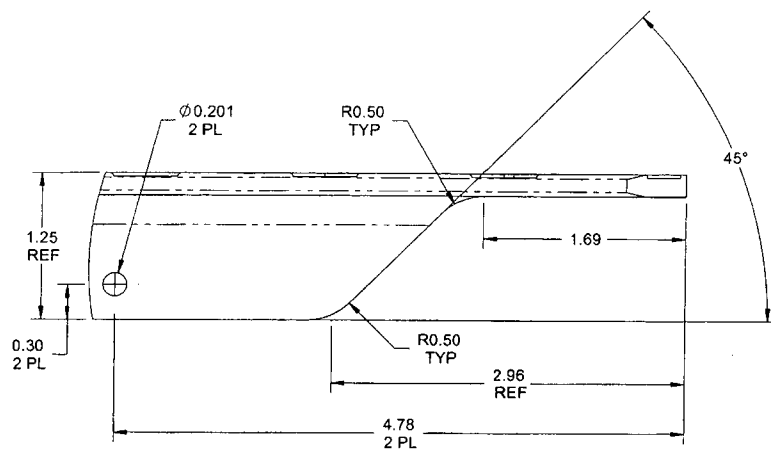
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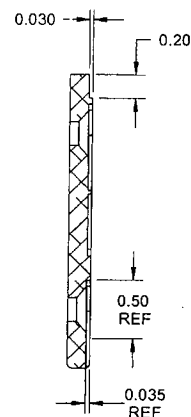
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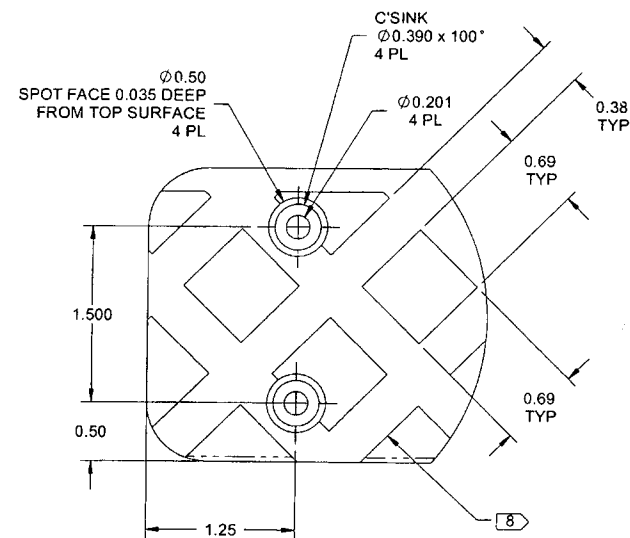
80698



DETAIL A B3-5
SCALE 3X, TYP



SECTION B-B C3-5
SCALE 3X, TYP



DETAIL C C8-5
SCALE 3X, TYP

RELEASED
2011-09-22

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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